

Work Order ID 60826

Friday, July 23, 2010 1:16:39 PM



Page 1

Item ID: D3794-3

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 7/23/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 8/27/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: *mk*

Date: *10-7-23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3794

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794

☐ Dwg Rev:

A

☐ Prog Rev:

A

☐ 2-

Deburr if necessary

10-7-26

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-7-26

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/27

(12)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

FPW

0.00



Packaging

Memo

0.00

Packaging

10/7/27

SP (12)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/28

BP 10-7-28

(12)

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Picklist Print

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Page 1

Work Order ID: 60826



Parent Item: D3794-3



Parent Item Name: Gasket

Start Date: 7/23/2010

Required Date: 8/27/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063

Purchased

No

100

sf

294.2233

1.2828

16.20379



NEOPRENE SHEET 0.063



1810-7-20

Location

Loc Qty

Loc Code

MAT

188.9702

114691

188.9702

MAT052

105.2531

114176

105.2531

114691

12

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60826
Description: Gasket		Part Number:	D3794-3
Inspection Dwg: D3794	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.191	✓		V B02	
0.300 x 0.300	+/-0.010	303 x 302	✓		V	
1.88	+/-0.030	1.884	✓		✓	
4.281	+/-0.010	4.279	✓		✓	
6.44	+/-0.030	6.425	✓		✓	
6.00	+/-0.030	6.00	✓		✓	
6.75	+/-0.030	6.75	✓		✓	
2.00	+/-0.030	2.000	✓		✓	
4.75	+/-0.030	4.75	✓		✓	
9.50	+/-0.030	9.50	✓		✓	
14.25	+/-0.030	14.25	✓		T B01	
17.75	+/-0.030	17.75	✓		T	
26.74	+/-0.030	26.74	✓		T	
29.23	+/-0.030	29.23	✓		T	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-7-26	Date: 10/9/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	

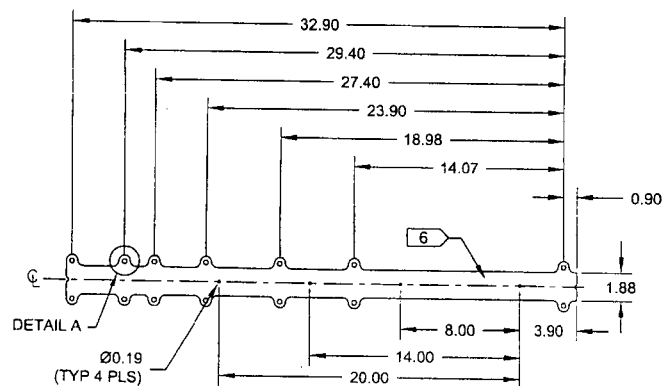
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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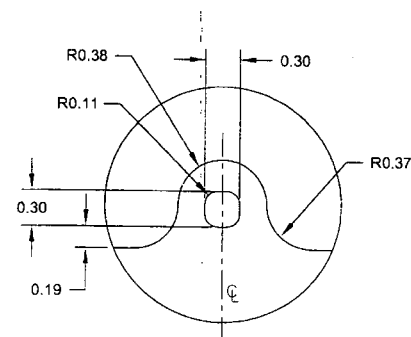
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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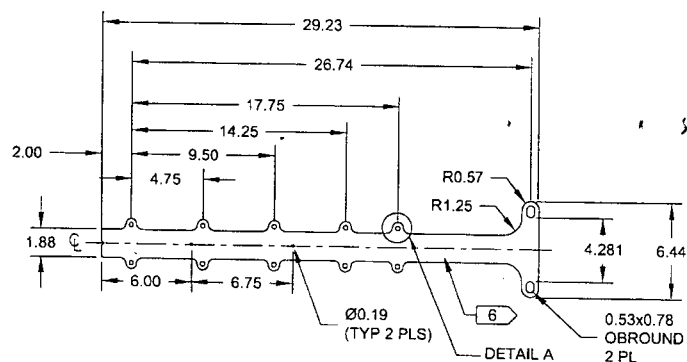
NOTE: Date & initial all entries



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

A	NEW ISSUE	PH	08.05.14
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3794	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GASKET	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

RELEASED
08-05-14

60826

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